

# Work Order ID 90270

Friday, September 14, 2012 8:46:24 AM

\*90270\*

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Item ID: D4170-1 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bushing  
 Start Date: 9/14/2012 Start Qty: 14.00 \*14\* Cust Item ID:  
 Required Date: 9/14/2012 Req'd Qty: 14.00 \*14\* Customer:  
 Reference:

Approvals: Process Plan: MP Date: 12-09-14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4170	B								

100  
 \*100\* Hardinge CNC LATHE SMALL 0.00  
 Hardinge Memo 0.00  
 Hardinge CNC Lathe Small Machine as per Folio FA962

110  
 \*110\* QC2- Inspect parts off machine FAI/FAIB 0.00  
 QC Memo 0.00  
 Quality Control

120  
 \*120\* QC8- Inspect parts - second check 0.00  
 QC Memo 0.00  
 Quality Control

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**\*90270\***

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Item ID: D4170-1

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bushing

Start Date: 9/14/2012 Start Qty: 14.00

**\*14\***

Cust Item ID:

Required Date: 9/14/2012 Req'd Qty: 14.00

**\*14\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

125

0.00

**\*125\***

Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

13 0 BE 12/10/01

130

Identify as per dwg & Stock Location: LG

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

\*\*\*STOCK IN SKIDTUBE CELL\*\*\*

13 0 BE 12/10/01

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/10/40

MF

12-10-02

# Picklist Print

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Work Order ID: 90270

Parent Item: D4170-1

Parent Item Name: Bushing

Start Date: 9/14/2012

Required Date: 9/14/2012

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD  
revB DD verf:EC

IPP Rev:A 10.11.02 as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058 6061-T6 RD Tube .375 x.058W		Purchased	No			100	f	113.0310	0.2666	3.9288421			

Location

Loc Qty

Loc Code

MAT014

113.031

116920

0.578

119087

6.055

119376

54.5

119678

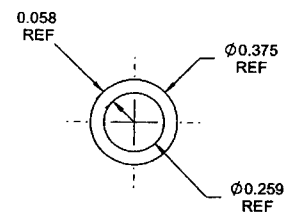
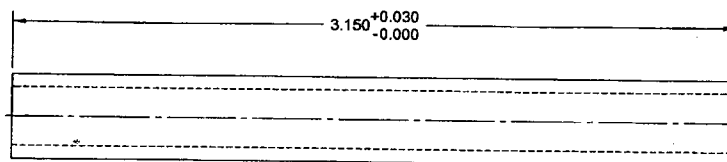
6

120633

45.898

4.0

12-09-13



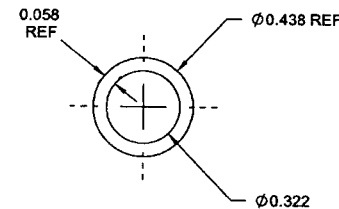
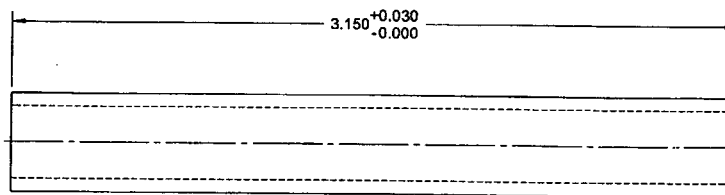
**D4170-1 SPACER**

**RELEASED**  
2010-11-01

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING,  $\phi 3/8$  OD X 0.058 WALL  
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8  
REF DART SPEC. M6061T6T0.375W.058
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

B	ADD -3 (SHEET 2)		CP	10.10.25
A	NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>		
DRAWN	JP	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		<b>D4170</b>	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		<b>SPACER</b>	NTS	
DATE	10.10.25		<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



**D4170-3 SPACER**

**RELEASED**  
2010-11-01

**NOTES:**

- 1) MATERIAL: 6061-T6 ROUND BAR,  $\phi$  7/16 OD  
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221  
REF DART SPEC. M6061T6R0.438
- OR  
6061-T6 OR 6061-T62 TUBING,  $\phi$  7/16 OD X 0.058 WALL  
PER WW-T-700/8, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8  
REF DART SPEC. M6061T6T0.438W.058
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	GP	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.		<b>D4170</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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